

Date: Tuesday, 28/08/2007 10:42:44 AM  
User: Linda Lacelle

**Process Sheet**

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HOUSING WELDMENT
<b>Job Number</b> : 33982	
<b>Estimate Number</b> : 11874	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2207041
<b>This Issue</b> : 28/08/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2207 UNDER REVIEW
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 16/08/2007 <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 32219	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 23/08/2007
<b>Checked &amp; Approved By</b> : _____	<b>Qty:</b> ① <b>Um:</b> Each
<b>Comment</b> : Est. 01.10.18 Added Step 10 and 11 - SM	

OK PER  
D2207 REV.C PRELIM  
ISSUE.  
2070828

**Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D2208	End Cap
-----	-------	---------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

End Cap

Pick:

Qty	Part Number	Description	Batch
2	D2208	End cap	B33239

07/08/31 ①

2.0	D22071	Housing
-----	--------	---------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Housing

Pick:

Qty	Part Number	Description	Batch
1	D2207-1	Housing	B34326

07/08/31 ②

3.0	LARGE FAB.1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



**Comment:** LARGE FABRICATION RESOURCE 1

Weld as per Dwg D2207

Grind welds flush as per Dwg D2207

07/08/31 ①

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



**Comment:** VISUAL WELDING INSPECTION

07-08-31 ①





Date: Tuesday, 28/08/2007 10:42:44 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WFLDMENT

Job Number: 33982

Part Number: D2207041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL FABRICATION RESOURCE 1  
Drill holes using DT8557 as per Dwg D2207

FF 07-09-04

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/04

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

M-L

07/09/04

(1X)

8.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105 068

FL

07-09-04

①

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/08/04 ①

10.0	ALS71032130	Insert
------	-------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Insert

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	ALS7-1032-130	Insert	M 102475
---	---------------	--------	----------

SEE QSI 017

FL

11.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
------	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1  
Install AK57-1032-130 as per Dwg D2207

FL 07/08/04 ①

12.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/04 ①



Date: Tuesday, 28/08/2007 10:42:44 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 33982

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*07/09/04* (1)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/09/04* (1)

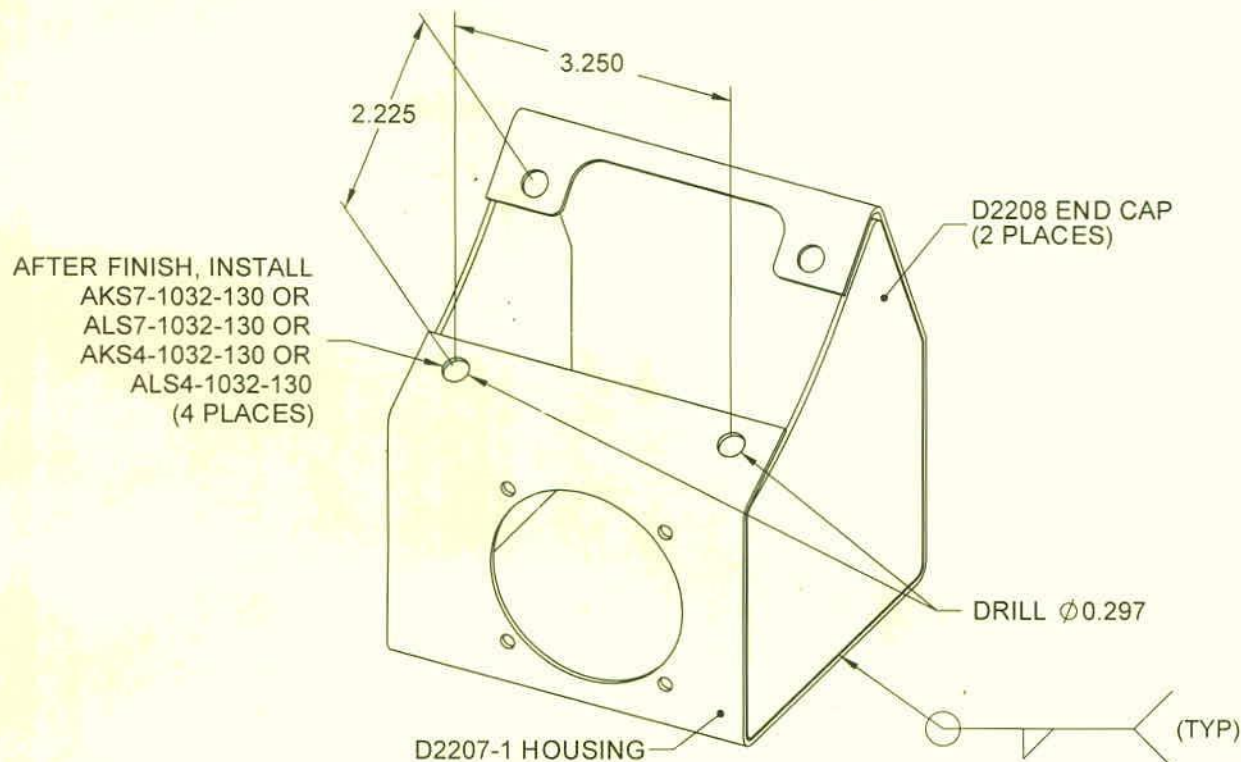
Job Completion



*07/09/04*







### D2207-041 HOUSING ASSEMBLY

**PRELIMINARY ISSUE**

07.06.28

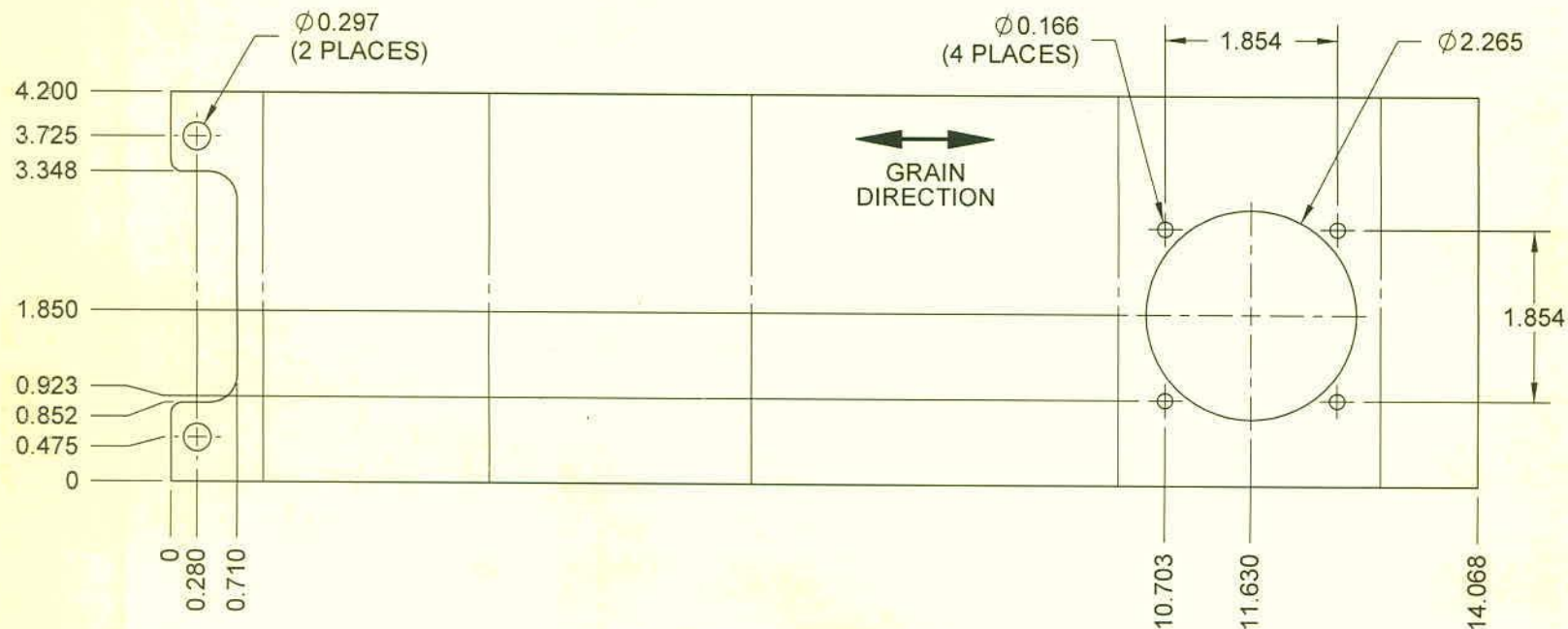
#### NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

REV.	DESCRIPTION	BY	DATE
C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D2207	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HOUSING	1:2
DATE	07.06.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

БРЕТАННА 12203

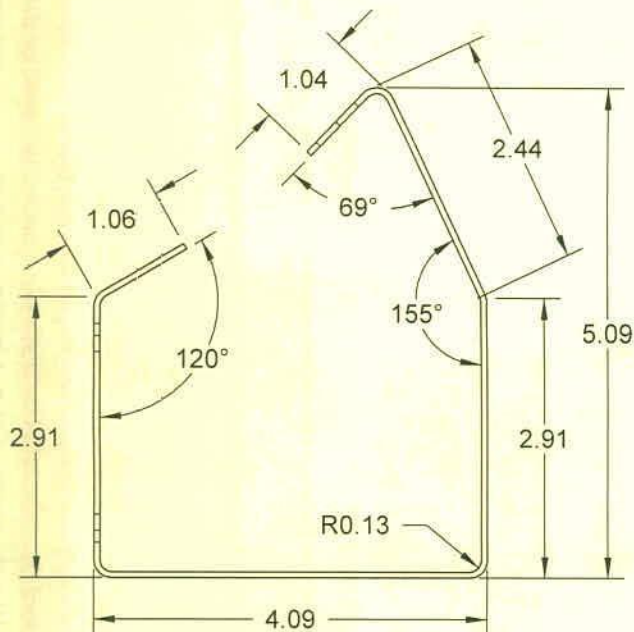




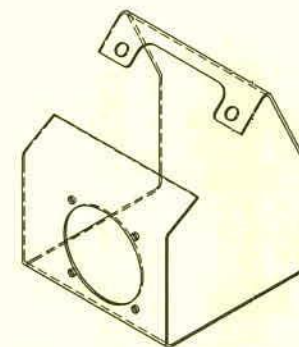
### D2207-1F FLAT PATTERN

#### NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.063) **OR**  
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



### D2207-1 BENDING DETAIL



**ISOMETRIC VIEW**  
(SCALE 1 : 4)

**PRELIMINARY ISSUE**

07.06.28

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>FE</i>	<b>D2207</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>HOUSING</b>	1:2
DATE	<b>07.06.28</b>	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

БЕЛІНІЧКА 13295